

Date: Monday, 18/08/2008 3:45:44 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER RESTRAINT WELDMENT
Job Number	: 41377		
Estimate Number	: 13398		
P.O. Number	:	Part Number	: PB674300131
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.41/ P.43
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 40064	Material	:
Written By	:	Due Date	: 18/09/2008 Qty: 8 Um: Each
Checked & Approved By	: <u>JD 08.8.18</u>		
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.4557 sf(s)/Unit Total : 3.6456 sf(s)
 6061-T6 .090 Sheet
 batch: 108595 B 8-8-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001-321
 Dwg Rev: B1 B 8-8-21
 Prog Rev: B1
 ***grain direction along 25.00" ***
 2-Deburr if necessary B 8-8-21

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/08/02 (10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Bend as per Dwg B67-43001

508/09/09 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/10 ECQ

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h 08/09/10

(10x)

8.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50
320 °C
9:20

M-h 08/09/13

(10x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 8/9/10 (10)

10.0

PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Upper Pad Assembly

batch:

22998 B41505

CP 08/10/09

11.0

NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch:

M10 8473

P

12.0

MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch:

107378

P 8/9/10 (10)

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QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per dwg B67-43001

CP 08/10/09 (10)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/09 (11)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5T510

SS 08/10/10 (10)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/10

Job Completion



MF 08-10-10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

